

## PATENT CLAIMS

1. A method for the automatic production of bags (9) each having a seal (3) with the following production steps:

feeding at least one plastic film (1) in order to form side walls,

feeding a seal (3) consisting of complementary sealing profiles (3),

attaching the seal (3) to the plastic film (1), and welding (7, 8) the plastic film (1) in order to create a bag (9),  
characterized in that

prior to feeding the seal (3) a perforation line (2) is formed in the plastic film (1) at a spacing from the panel edge (5) and

the complementary sealing profiles (3) are attached to the plastic film (1) immediately above the perforation line (2) and that

subsequently the bag (9) is formed and finally the bag is created by means of at least one longitudinal (7) and/or at least one transverse weld (8).

2. The method according to claim 1, characterized in that a slide (4) is attached to the sealing profile (3).

3. The method according to any one of claims 1 or 2, characterized in that the sealing profile (3) is sealed or glued

to the plastic film (1) or is connected to the plastic film (1) nondetachably by means of an extrusion process.

4. The method according to claim 1, characterized in that the perforation line (2) is formed in the plastic film (1) in the travel direction (P) of the plastic film (1) and that the bag is created by means of at least one longitudinal weld (7) and at least two transverse welds (8).

5. The method according to any one of claims 1 to 4, characterized in that the perforation line (2) is formed in a center (6) of the plastic film (1).

6. The method according to any one of claims 1 to 5, characterized in that the plastic film (1) is guided over a forming shoulder for forming of bag (9) and that the plastic film (1) is formed for the creation of a bag (9) that is open on one side by means of one transverse weld (8) and one longitudinal weld (7).

7. The method according to claim 6, characterized in that the open bag (9) is filled with a product prior to sealing.

8. A machine for the automatic production of a bag (9) with a seal (3) for implementation of the method according to any one of claims 1 to 7, characterized in that the machine has the following:

means suitable for guiding a plastic film (1) with the  
at least one plastic film (1) forming the walls of the bag (9),  
means for forming the perforation line (2) in the  
plastic film (1),

5 means for the continuously feeding, separating, and  
attaching the seal (3) to the plastic film (1), and

means for forming, filling and sealing the plastic  
film (1).

9. The machine according to claim 7, characterized in  
10 that the means for perforating (2) and for feeding, separating  
and attaching the seal (3) are arranged upstream of the shaping,  
filling (8) and sealing (7, 8) means.

10. The machine according to any one of claims 8 and  
15 9, characterized in that the machine forms an automatic machine  
for the production, filling (B) and sealing (7, 8) of bags (9).